

May-08-12 8:40:49 AM

**\*84227\***

Page 1

**Accept**

**\*N900040100\***

Setup Start. \*NS1\*

Stop \*NS2\*

**Item Name:** Bearpaw, 206

**Start Date:** 08/05/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 22/05/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

Approvals: Process Plan: MLJ

Date: 17/05/2020

### Tooling:

**Date:**

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):**

**Date:**

Stop **\*NR2\***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84227**

May-08-12 8:40:49 AM

**\*84227\***

Page 2

Item ID: D2435

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw, 206

Start Date: 08/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

B-A 12/06/30

12-06-29 (X4)

Quality Control

4

0

151

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*151\***

Packaging

Memo

0.00

PPP84226

12/7/3 (4)

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

12/7/3 (4)

Quality Control

MRF  
12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

May-08-12 8:40:53 AM

Page 1

Work Order ID: 84227

\*84227\*

Parent Item: D2435

\*D2435\*

Parent Item Name: Bearpaw, 206

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	53.2100	3.2	12.8			

\*MUHMWB10\*

UHMW 1" Black

\*\*

1312-62

Location	Loc Qty	Loc Code
MAT018	30.1	
120972	3	
121346	27.1	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

121851

121851

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	84227
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2435
<b>Inspection Dwg:</b> D2435	<b>Rev:</b> E1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.076	✓		vern	RT-4
B	5.500	+/-0.030	5.504	✓		"	
C	0.200	+/-0.030	.191	✓		depth gauge	RT-6
D	R0.250	+/-0.030	.250	✓		rad gauge	
E	0.250	+/-0.010	.260	✓		vern	RT-4
F	0.625	+/-0.030	.646	✓		vern	
G	0.25 x 45°	+/-0.030	.253	✓		"	
H	0.375	+/-0.010	.384	✓		"	
I	19.000	+/-0.030	19.000	✓		Tape	RT-10
J	0.950	+0.030/-0.010	.960	✓		vern	RT-4
K	Ø0.260	+0.005/-0.000	.260	✓		"	
L	Ø0.930	+/-0.030	.929	✓		"	
M	0.30	+0.030/-0.000	.305	✓		depth gauge	RT-6
N	0.375	+/-0.030	.381	✓		vern	RT-4
O	7.375	+/-0.030	7.375	✓		Tape	RT-10
P	4.250	+/-0.010	4.257	✓		vern	RT-4
Q	2.000	+/-0.030	2.000	✓		"	
R	9.000	+/-0.010	9.000	✓		Tape	RT-10
S	15.750	+/-0.030	15.750	✓		"	

<b>Measured by:</b> RT	<b>Audited by:</b> B.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12 06 29	<b>Date:</b> 12/06/30	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





RELEASED  
98.06.17 KE

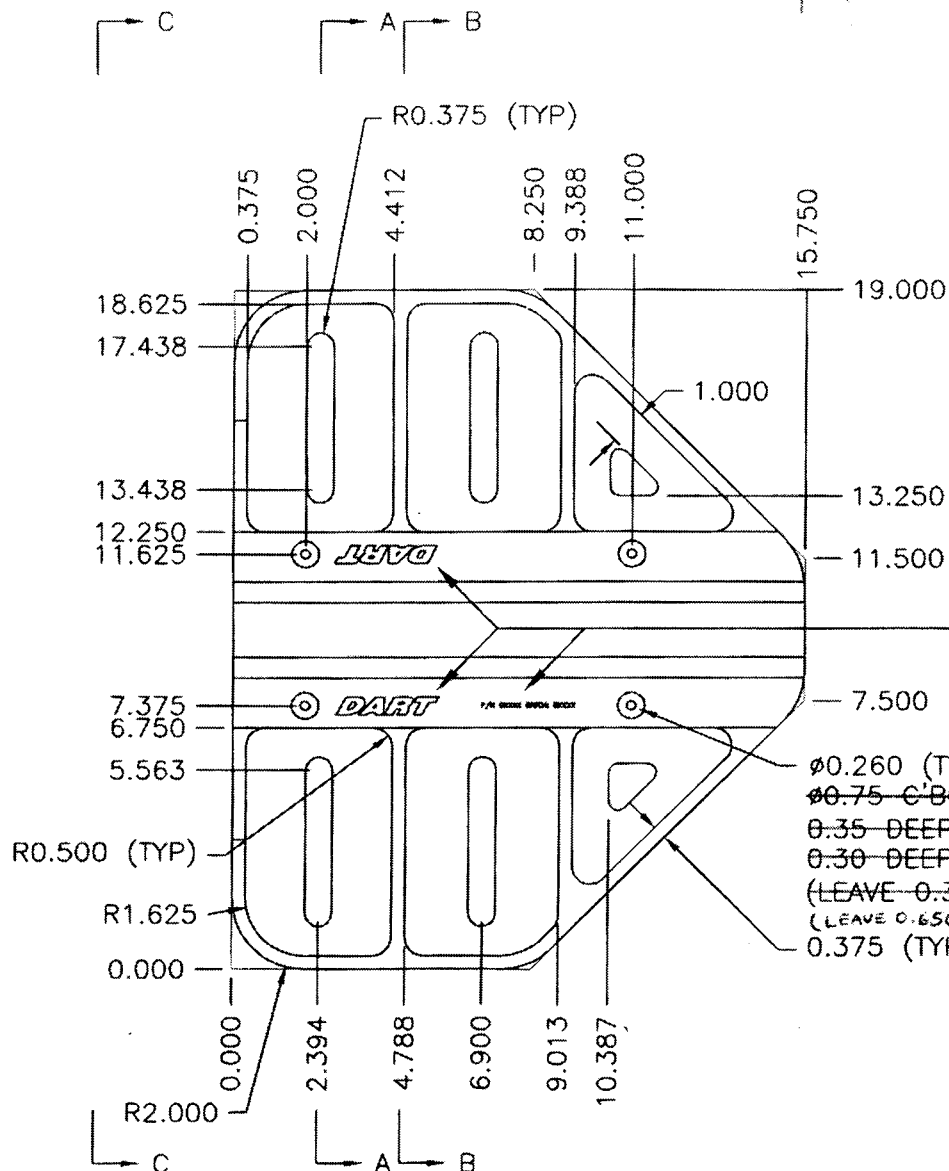
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED KE	APPROVED KE	HAWKESBURY, ONTARIO, CANADA
DATE 98.05.19	DRAWING NO. D2435	REV. E
	TITLE BEARPAW	SHEET 1 OF 2
	SCALE 1:5	

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84227 MLW  
12/05/08

$\phi 0.260$  (TYP)  $\phi 0.93$  C'BORE  
 ~~$\phi 0.75$  C'BORE~~ 0.30 DEEP FROM BOTTOM  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375 (TYP)

9143	
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MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

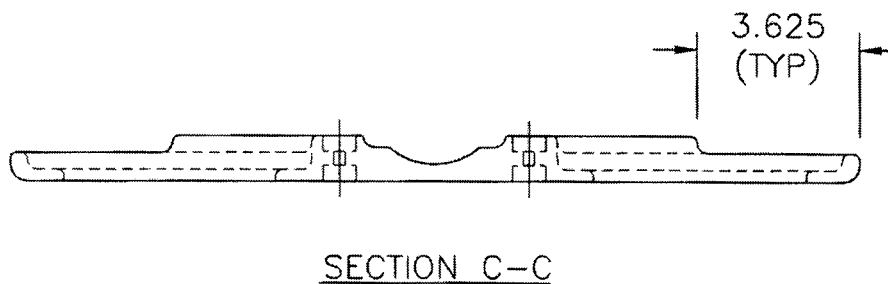
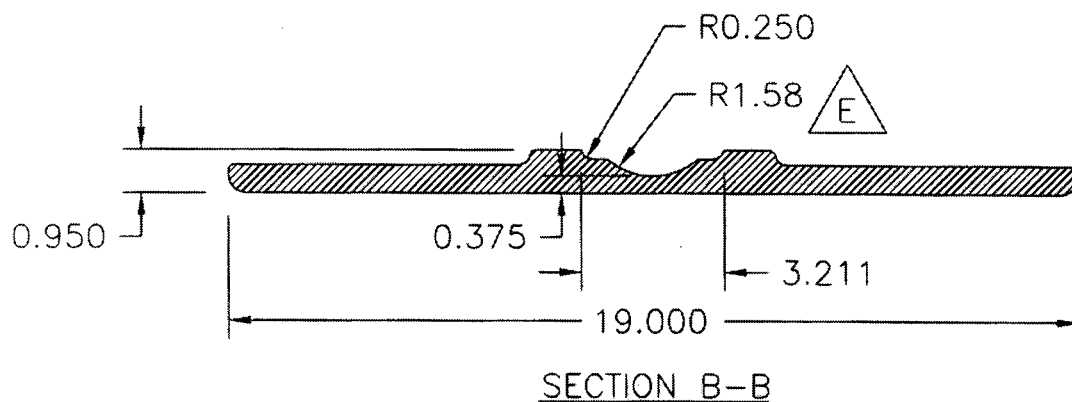
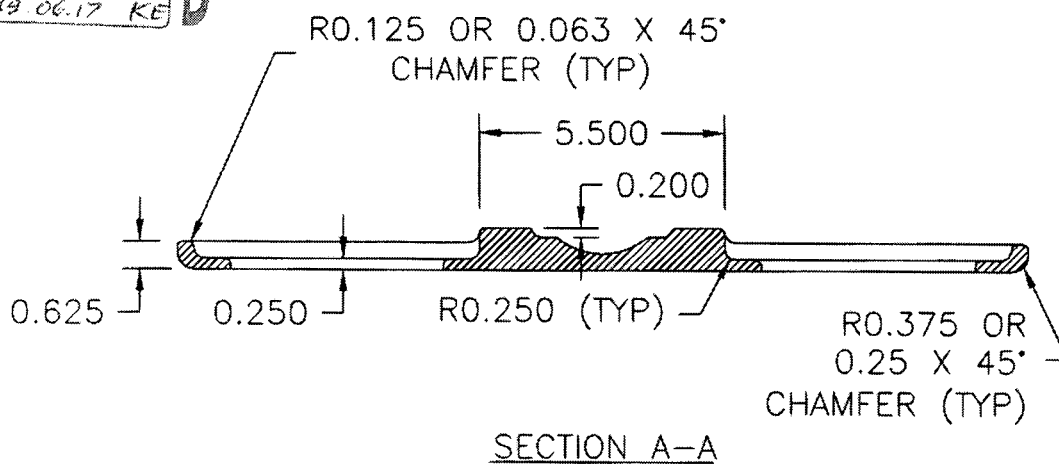
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED KS	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



84227

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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